

Work Order ID 149484

July 26, 2016 4:33:42 PM

149484

Page 1

Item ID: D206-642-312BL REPAIR Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube RH, Low & High Gear with Standard Wearplates (Ael Blue)
 Start Date: 7/26/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/27/2016 Req'd Qty: 1.00 ***1*** Customer: CAEVA02
 Reference: RMA RA112340

Approvals: Process Plan: zu Date: 7/26/16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

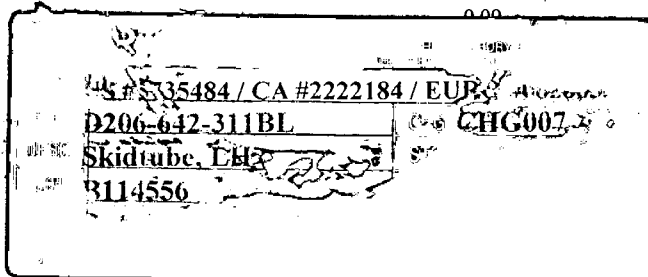
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D206-642	Q

105 0.00 ***105*** DAS
 QC 0.00 D 16-07-27 9
 Quality Control Memo INSPECT D206-642-312BL REPAIR X 1 B106438 X 1 ON RA112340 9-89

110 0.00 ***110***
 Skidtubes Memo 0.00 1 16-7-27
 Skidtubes TO PERFORM ITEMS 2-6 ON THE REPAIR SCHEME

115 0.00 ***115***
 QC 0.00 D 16-07-27
 Quality Control QC5- Inspect part completeness to step on W/O



B 149484

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
		OTHER :																							

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120									
HandFinish	Memo	0.00							
Hand Finishing	TO PERFORM ITEM 7 ON THE REPAIR SCHEME								
121		0.00							
121									
SprayPaint	Memo	0.00							
Spray Painting	PRIME AS PER REPAIR SCHEME								
	134518								
125	QC5- Inspect part completeness to step on W/O	0.00							
125									
QC	Memo	0.00							
Quality Control									

DAS
34

2016/07/27
BEB

1
AB
16-7-28

① 16-07-20 PD

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Skidtubes	Memo	0.00							
Skidtubes	✓ TO PERFORM ITEMS 8-10 ON THE REPAIR SCHEME								
135	QC5- Inspect part completeness to step on W/O	0.00							
135									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: _____	0.00							
140									
Packaging	Memo	0.00							
Packaging	ID AS REPAIR WITH NEW BATCH NUMBER AT CHANGE 007								
	RETURN TO CUSTOMER								

1 x 9 JLL 16/07/20

① 16-07-20 PD

DAS
28
9-89
DAS
27
9-89

JUL 29 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐									
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval					
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Root Cause		FAULT CATEGORY											
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		OTHER : ☐											

Work Order ID 149484***149484***

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July 26, 2016 4:33:42 PM

Item ID: D206-642-312BL REPAIR

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH, Low & High Gear with Standard Wearplates (Ael Blue)

Start Date: 7/26/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/27/2016 Req'd Qty: 1.00 ***1***

Customer: CAEVA02

Reference: RMA RA112340

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

145

QC21- Final Inspection - Work Order Release

0.00

145

QC

Memo

0.00

Quality Control

Handwritten signatures and date: 16/07/2016

SA 7/29/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

Picklist Print

July 26, 2016 4:33:46 PM

Page 1

Work Order ID: 149484

149484

Parent Item: D206-642-312BL REPAIR

D206-642-312RI REPAIR

Parent Item Name: Skidtube RH, Low & High Gear with Standard Wearplates (Ael Blue)

Start Date: 7/26/2016

Required Date: 7/27/2016

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D206-642-312BL
REPAIR

Manufactured No

Each 0.0000

1

D206-642-312RI REPAIR

Skidtube RH, Low & High Gear with Standard Wearplates (Ael Blue)

**

DAS
27
9:59

B106439

JUL 29 2016

Repair scheme for D206-642

Skidtube Toe Ring Repair

1. Remove Toe Ring and AN4 bolt from D2680-041 and end cap D2646
2. Clean D2680-041 to ensure a good bond when re-installed
3. Remove the remaining rivet by gripping the rivet tail with a small pair of bent needle nose pliers and prying gently while tapping with a small punch, while supporting the surface around the rivet
4. Countersink forward (2) holes to accommodate 1/8" rivets
5. Cleco D2680-041 onto Skidtube, if you find the surface to have uneven surface, gently tap the surface flat with the use of a bucking bar and hammer to flatten the surface, reinstall D2680-041 and open the 4 holes to #27 drill
6. Using a scotch brite pad in a Die Grinder, remove any corrosion and paint 1/8" around the perimeter of the D2680-041
7. Wipe clean, alodine and mask off prior to primer
8. Once the surface of the skidtube in the area of the repair is cured mix the CB200 adhesive and apply to the lower surface of the D2680-041, ensuring a nice equal layer of adhesive
9. Using 1/8" clecos position the D2680-041 into place and one by one install the CR3242-4-3
10. Let cure and install Toe Ring according to ICA-D206-642 Rev. 6 Chapter 32.6.3

Material required (Consumable)

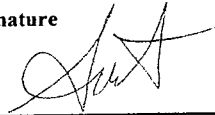
1. CR3242-4-3 Cherrymax Rivet
2. CB200 Adhesive
3. Primer
4. PRD 870, 1422 (as required)
5. Topcoat

Equipment Required

1. Hand Rivet Puller
2. Die Grinder with Roloc Mandrel
3. Scotchbrite pad, Medium Grit
4. Spatula
5. Hand Drill
6. 1/8" Clecos
7. Paint Sprayer, masking tape, paint brush

Perform by	QC approval	QA approval
<i>AS</i> <i>James Jones</i>	DAS 9 9-80	<i>See Acc.</i>

8/6/29

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE Form One			3. Form Tracking Number: SO127232
4. Organizations Name and Address: Dart Aerospace Ltd., 1270 Aberdeen Street, Hawkesbury, Ontario, K6A 1K7, CANADA Tel: 1 (613) 632-5200 Fax: 1 (613) 632-5246 www.dartaero.com				5. Work Order/Contract/Invoice WPO-000020-16	
6. Item:	7. Description:	8. Part Number:	9. Quantity:	10. Serial/Batch Number:	11. Status/Work:
1	Skidtube, RH, Low & High Gear with Standard Wearplates	D206-642-312	1	B149484	Repaired
12. Remarks: Skidtube P/N D206-642-341 repaired according to DART repair scheme on work order B149484. All additional customer supplied items were not inspected or repaired. To be evaluated by customer.					
13a. Certifies that the items identified above were manufactured in conformity to: ☐ Approved design data and are in a condition for safe operation. ☐ Non-approved design data specified in Block 12.			14a. ☒ CAR 571.10 Maintenance Release ☐ Other regulations specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12, has been performed in compliance with the <i>Canadian Aviation Regulations</i> .		
13b. Signature		13c. Approval Organization Number		14b. Signature	14c. Approved Organization Number
				 DAS 29 9-88	9-89
13d. Name		13e. Date (dd/mm/yyyy)		14d. Name	14e. Date (dd/mm/yyyy):
				Patrick Smith	28/Jul/2016
30 Dec 2008(Previously form 24-0078)					
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than the authority specified in Block 1, must ensure that their regulations recognize certifications from the country specified. Statements 13a or 14a do not constitute installation certification. In all cases, the aircraft technical record must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					